



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2665-1

Job Sheet 212146



Part No: D2665-1

Job Qty: 2 pcs

DAS
21
9-89

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/11/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/28/20

Type: Stock **SOLD**

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D
07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

90 Machining-Issue SW - HAAS 1					Standard		Workcenter/Supplier		DAS 20-08-19	
Op No	Operation	Qty	Start Date	Due Date	Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	DAS	Sign-off
100	HAAS 4 Axis	2 pcs	8/27/20	8/27/20	1.00	3.08	HAAS - 1 - B4B	52	9-89	20/08/20
							HAAS - 2			
							HAAS - 3			
							HAAS - 4	DAS		
110	Conventional Mill - 1 - B4B	2 pcs	8/27/20	8/27/20	0.00	0.33	Conventional Mill - 1 - B4B	52	9-89	20/08/20
							Conventional Mill - 2 - B4B			
120	QC 2	2 pcs	8/27/20	8/27/20	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51	DAS	52	20/08/20
							QC 2 - 52	9-89		



Container No: S294939



Part: D2665 - 1
Job No: 212146
Serial No/Batch: S294939

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 08/19/20



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Date: 08/19/20

Plex 8/11/20 2:35 PM Dart.lajeunesse.marie

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	2 pcs	8/27/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	J.C.L. 20-08-22
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	2 pcs	8/27/20	0.00 0.14	Handfinish - 1 - 1 - B4B	20-08-21
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	

				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B <i>m 254-69</i>	2 pcs	8/28/20	0.00 0.10	Powdercoat - 1 - B4B	
<i>START: 1:10</i>				Powdercoat - 2 - B4B	
<i>O.T. 300°</i>				Powdercoat - 3 - B4B	<i>20-04-24</i>
<i>FINISH 1:40</i>				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	2 pcs	8/28/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
170 Packaging 3-1 - Stock - B4B <i>3</i>	2 pcs	8/28/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	<i>ST402</i>
				Packaging 3 - 4 - B4B	<i>AUG 25 2020</i>
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	2	8/28/20	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	

AUG 25 2020

DAS

21

9-89

Part Op **100** - HAAS CNC Vertical Machine Program batch number, 1- Inspect part number and batch number are programmed
 Descriptions: correctly, 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of
 Folio and visually inspect as per attached Dimension Sheet
110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
160 - QC3- Inspect Part Finish Standard Process
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	2 pcs (1 ea)	100-HAAS 4 Axis	S293969

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	2	0	0

Part Specifications

Specifications could not be found.

Plex 8/11/20 2:35 PM Dart.lajeunesse.marie

DART AEROSPACE LTD				Work Order: 212146	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.120	0.141	0.122		
B	0.100	0.140		0.130	0.135	0.129		
C	1.125	1.145		1.135	1.135	1.135		
D	0.615	0.685		0.670	0.670	0.670		
E	0.240	0.260		0.2495	0.259	0.251		
F	1.313	1.343		1.324	1.314	1.324		
G	0.210	0.230		0.219	0.220	0.220		
H	0.100	0.180		0.128	0.130	0.130		
I	2.470	2.510		2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575		
K	0.235	0.240		0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110		
M	0.990	1.010		1.002	1.009	1.002		
N	0.510	0.515		0.512	0.512	0.519		
O	5.990	6.010		6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500		
R	0.312	0.318		0.313	0.313	0.313		
S	0.315	0.322		0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362		
V	0.787	0.807		0.795	0.795	0.795		
W	0.540	0.560		0.548	0.549	0.547		
X	1.674	1.684		1.679	1.679	1.679		
Y	0.256	0.262		0.258	0.258	0.258		
Z	0.912	0.932		0.923	0.923	0.923		
AA	0.490	0.510		0.503	0.503	0.505		
AB	0.178	0.198		0.188	0.188	0.188		
AC								
AD								
AE								
Accept/Reject								

Measured by: JIP / 52	Date: 20/08/20
Audited by: J.C.V. 980	Date: 20/08/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	M

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				
Other/Details:					